

Work Order ID 120969

120969

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Thursday, July 24, 2014 11:47:57 AM

Item ID: D2965-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 6/16/2014 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 6/16/2014 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: CL Date: 14/07/24 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2965	Rev B								
102		0.00							
102									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>25144</u>								
	Cast per Dwg D2965								
	Material Release Note Required								
104	Receive & Inspect for Damage & Mat'l Certs	0.00							
104									
Packaging	Memo	0.00							
Packaging	Material Release Note Required								
106	QC6- Inspect dimensions to drawing	0.00							
106									
QC	Memo	0.00							
Quality Control									

CL 14/07/24 40

Fx SP14-8-19

(7) DAS 38 14-8-22
 9-89

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June-16-14 1:14:48 PM

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Item ID: D2965-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 6/16/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/16/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00				7	0		J.C.-L. 14/09/09
110		0.00							
Mill Conv	Memo								
Conventional Milling Machine	MILL SLOT								
111	QC2- Inspect parts off machine FAI/FAIB	0.00				7	0		J.C.-L. 14/09/09
111		0.00							
QC	Memo								
Quality Control									
120	QC8- Inspect parts - second check	0.00				7	0		
120		0.00							
QC	Memo								
Quality Control									

*NCR at the end

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Item ID: D2965-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cap
 Start Date: 6/16/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 6/16/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							9-89
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: FP-001 Memo FP-001	0.00 0.00							9-89
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							9-89

7- 14/09/11
 7- 14-9-22 DAS 34 9-89

7x SP 14-9-11
 XZ f all blocks

MIS 1409-22

40-22

Picklist Print

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Work Order ID: 120969

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Parent Item: D2965-3

D2965-3

Parent Item Name: Cap

Start Date: 6/16/2014

Required Date: 6/16/2014

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev A New Issue 06-12-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225	AELS8-1032-225	Purchased	No			170	Each	1,019.000	2	80	14		
AI S7-1032-225										**	del 4/09/22		
Insert													

Location

Loc Qty

Loc Code

FG

80

118520

80

FP001

852

m128649

852

ST280

87

m128179

87

D2965P

Purchased

No

104

Each

0.0000

1

D2965P

Cap

**

40-7x

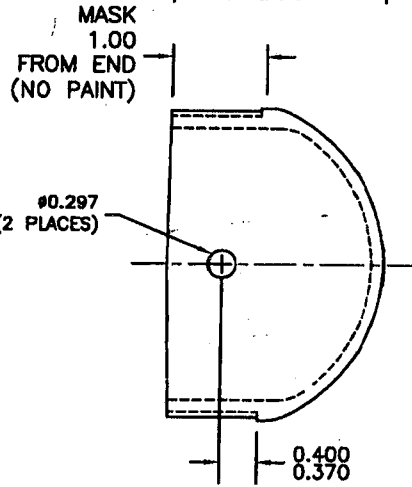
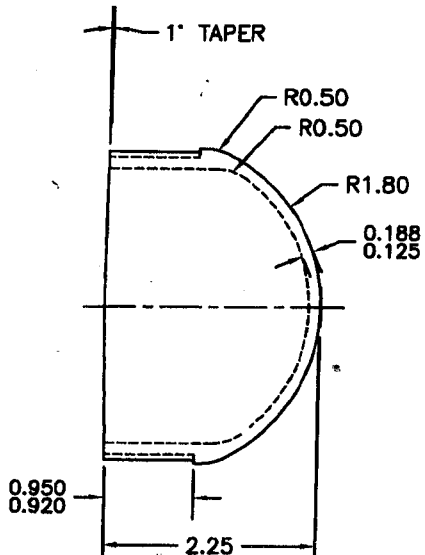
SP 14-8-19



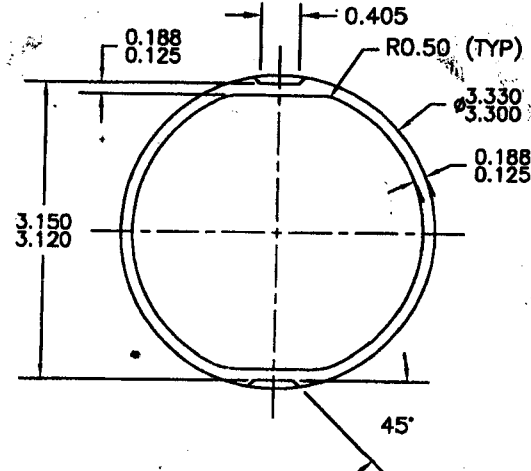
RELEASED

06.12.12

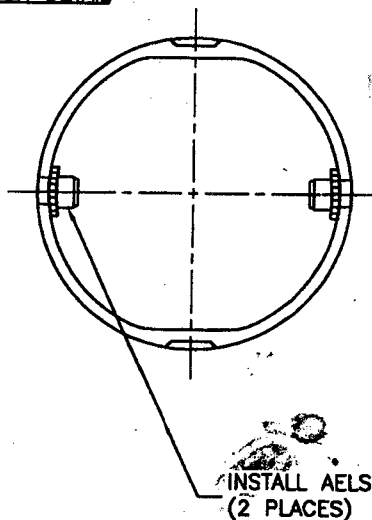
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
04	04	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
		D2965	
DATE	TITLE	SCALE	
06.11.01	CAP	1:2	
A	00.02.24	NEW ISSUE	
B	06.11.01	ADD -3 CAP	



D2965 CASTING DETAIL



D2965 FINISH DETAIL



INSTALL AELS-1032-225 INSERT (2 PLACES)

D2965_CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES

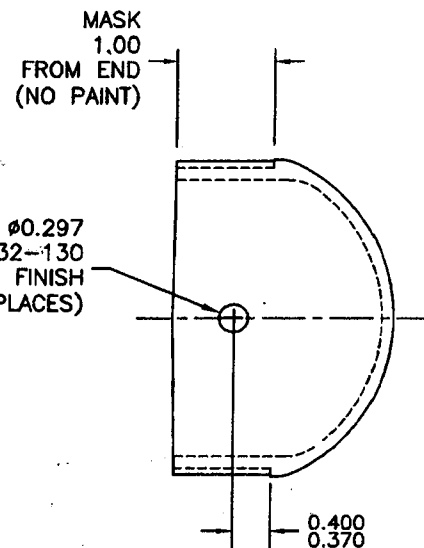
SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
120969
MW
14-06-17

DART

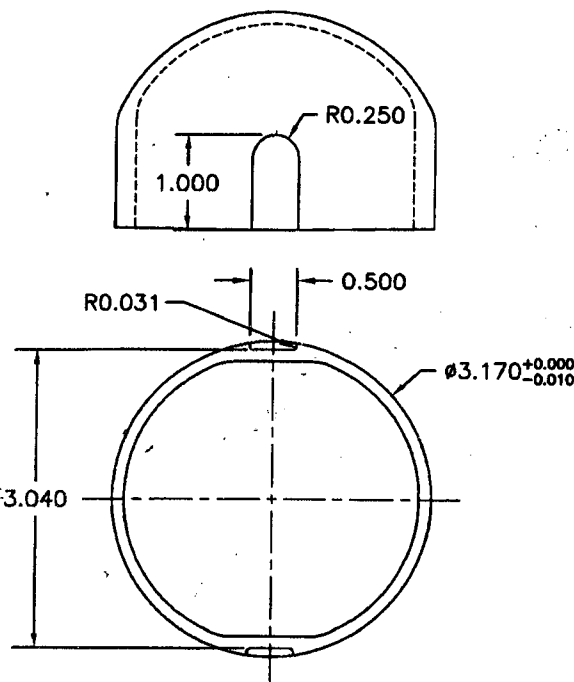
RELEASED

06.12.12

DESIGN	BY	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	BY	APPROVED	PORT HADLOCK, WA
DATE	06.11.01	TITLE	CAP
DRAWING NO.	D2965	REV. B	
SHEET 2 OF 2		SCALE	1:2



D2965-3 FINISH DETAIL



D2965-3 CAP MACHINING DETAIL
(MAKE FROM D2965 CAP)

D2965-3 CAP

- 1) MATERIAL: MAKE FROM D2965 CAP
- 2) FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25144**

Purchase Order Date 7/24/2014

PO Print Date 8/13/2014

Page Number 1 of 2

Order From :

METALLURGIE SYCA
500 PRINCIPALE

ST.DOMINIQUE, QUEBEC JOH 1LO

VC-MSY01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-261-0853

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extend Pri
----------	---	------------------------	--------------------------------------	----	--------------------------------	---------------	---------------

1	D2965P	Cap	9/8/2014 Yes 9/8/2014		100.00 Each	\$12.50	\$1,250.00
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AS PER DWG D2965 REV. B
B120696

NOTE

8 castings to be made for First Article Inspection.

Line Total:

\$1,250.00

PO Instructions: FEDEX ACC#151793240

Note:

8/13/2014

MÉTALLURGIE SYCATMC
500 RUE PRINCIPALE
ST-DOMINIQUE, QUÉBEC
J0H 1L0

N° D'ENR. DE TAXE
TAX REG. NO.

N° DE COMMANDE
ORDER NO.

VENDU À
SOLD TO

ADRESSE
ADDRESS

EXPÉDIÉ À
SHIP TO

ADRESSE
ADDRESS

DATE 15 Août 2014

P025144

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKSBURY ONT

K6A 1K7

DATE D'EXPÉDITION
SHIPPING DATE

VIA

CONDITIONS
TERMS

ACHETEUR
BUYER

VENDEUR
SALESPERSON

7 Echantillon D-2965

1 Box x 7 Pcs x 3 LBS

Transport

8014-8-19

Thanks for your Support

386304

BlueLine DCB27

SIGNATURE

TOTAL

FORMULAIRE DE VENTE - SALES ORDER

©BlueLine® 2010

DQA:

Date: 14/09/09

DART
AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 14/12/12

Work Order update only ☐

Work Order: <u>120 969</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2965-3</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>NCR 14-4277</u>		Machining <input type="checkbox"/>	Small Fab <input checked="" type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design				Hole is offset by 0.080";					
Doc/Data				0.480 insted of 0.400.	DAS 12 9-89	Acceptable -	DAS 12 9-89	14/09/10	DAS 9 9-89
Equip/Tooling									
Handling/Pre									
Material	14/10/02	110		RC. Material / casting	14/9/9	Cosmetic only	14/9/9		14-09-16
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input checked="" type="checkbox"/> Material / casting	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input checked="" type="checkbox"/> Other
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MÉTALLURGIE SYCA Inc.
500, Principale
St-Dominique, Québec
J0H 1U0
Tél: (450) 261-0853
Fax: (450) 261-0894
E-mail: syca@qc.aira.com
WWW.SYCA-INC.COM

FORMULAIRE D'ACCEPTATION DE PIÈCE

NOM DU CLIENT:	DART AEROSPACE LTD
NUMÉRO DE COMMANDE:	PO25144 (11786)
CODE DE PIÈCE:	D-2965
DESCRIPTION DE LA PIÈCE:	CAP D-2965
ALLIAGE:	ALU-135
NOMBRE D'ÉCHANTILLONS:	7

RAPPORT(S) FOURNI(S)

- ☒ Rapport dimensionnel
☐ Analyse chimique
☐ Autres:

ÉLÉMENTS D'ACCEPTATION: (À REMPLIR PAR LE CLIENT)

-Dimensionnel:	Accepté <input checked="" type="checkbox"/>	Refusé _____
-Aspect visuel:	Accepté <input checked="" type="checkbox"/>	Refusé _____

Commentaires: _____

Je reconnais que les échantillons fournis correspondent aux critères exigés et que tous les tests afférents (mécaniques, physicochimiques ou autres) ont été effectués.

Signature du client: DAS
9
289

Date 14-09-16

Ce document doit nous être retourné signé en foi de quoi le ou les échantillons fournis sont acceptés. Dès lors Métallurgie Syca inc. s'engage à procéder à l'exécution de la commande en respectant les critères du ou des échantillons fournis.

No. De Fax : 450-261-0894

courriel : syca@qc.aira.com

